

Work Order ID 108848-2

\*108848\*

Page 1

Item ID: D3560-042

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Arm Weldment

Start Date: 10/29/13 Start Qty: 6.00

\*6\*

Cust Item ID:

Required Date: 10/29/13 Req'd Qty: 6.00

\*6\*

Customer:

Reference:

Approvals: Process Plan: MLS

Date: 13-10-30 Tooling:

Date:

Run Start \*NR1\*

QC:

Date: SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan  
Code Accept Reject Reject Insp.  
Qty Qty Number Stamp

Draw Nbr

Revision Nbr

D3560

Rev D

130

Pick Kit

0.00

\*130\*

Packaging

Memo

0.00

Packaging

N/A MLS 1404-23

# Work Order ID 108848

\*108848\*

Page 2

Item ID: D3560-042

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Arm Weldment

Start Date: 10/29/13 Start Qty: 6.00

\*6\*

Cust Item ID:

Required Date: 10/29/13 Req'd Qty: 6.00

\*6\*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.  
Code Qty Qty Number Stamp

140

0.00

\*140\*

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Weld assembly as per dwg D3560  
STEP:  
1- clean material (buff bracket and bottom of arm with blue pad )  
2- set up bracket and arm on jig  
3- preheat bracket and arm with torch  
4- clean before welding with brush  
5- set up machine to 135 amps  
6- weld across bottom and top ends  
7- reheat with torch ( 65 deg C )  
8- on one side weld from bottom to top half way  
9- same for other side (half way)  
10- from half way point weld the rest of the first side (ease off pedal near end)  
11- same for remaining side (ease off pedal near end)

(5) 14-04-16 PD

150

QC5- Inspect part completeness to step on W/O

0.00

\*150\*

QC

Memo

0.00

Quality Control

5

14-4-22

DAS  
24  
9-89

# Work Order ID 108848

October-29-13 10:09:24 AM

\*108848\*

Page 3

Item ID: D3560-042

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Arm Weldment

Start Date: 10/29/13 Start Qty: 6.00

\*6\*

Cust Item ID:

Required Date: 10/29/13 Req'd Qty: 6.00

\*6\*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

160

QC9- Inspect visual per QSI004- Fusion Welds

0.00

\*160\*

QC

Memo

0.00

Quality Control

170

Chemical Conversion Coat per QSI005 4.1

0.00

\*170\*

HandFinish

Memo

0.00

Hand Finishing

180

QC3- Inspect Part Finish

0.00

\*180\*

QC

Memo

0.00

Quality Control

5

14.420  
DAS  
24  
9-89

5

76.144-23

5x

14/04/23  
DAS  
36  
9-89

# Work Order ID 108848

\*108848\*

Page 4

Item ID: D3560-042

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Arm Weldment

Start Date: 10/29/13 Start Qty: 6.00

\*6\*

Cust Item ID:

Required Date: 10/29/13 Req'd Qty: 6.00

\*6\*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

\*190\*

Small Fab

Small Fab

Small Fab

Memo

I-Press bushing in D3560 arm per dwg D3562

0.00

0.00

Sx

14/04/23

DAS  
36  
9-89

200

\*200\*

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

S

14/4/23

210

\*210\*

Packaging

Packaging

Identify as per dwg & Stock Location W31003

Memo

\*\*\* STOCK IN STEP CELL\*\*\*

0.00

0.00

Sx

14-4-23

DAS  
28  
9-88



Wbrk Order ID 108848

\*108848\*

Page 5

Item ID: D3560-042

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Arm Weldment

Start Date: 10/29/13 Start Qty: 6.00

\*6\*

Cust Item ID:

Required Date: 10/29/13 Req'd Qty: 6.00

\*6\*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	--------------	---------------	---------------	------------------	----------------

220

QC21- Final Inspection - Work Order Release

0.00

\*220\*

QC

Memo

0.00

Quality Control

MLJ 14-04-23

MLJ 14-04-23

# Picklist Print

October-29-13 10:09:24 AM

Page 1

Work Order ID: 108848  
Parent Item: D3560-042  
Parent Item Name: Arm Weldment

Start Date: 10/29/13

Required Date: 10/29/13

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07.05.24 EC  
IPP rev B ECN 987 07.10.09 EC verified by: DD  
IPP Rev:C ECN1048 07-12-18 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2808 Spacer		Manufactured	No				Each	44.0000		6			
-----------------	--	--------------	----	--	--	--	------	---------	--	---	--	--	--

Location	Loc Qty	Loc Code
GA	44	
103647	22	
105456	17	
85479	5	

14/04/23 DAS 36 9-89

D3560-2 Arm		Manufactured	No				Each	6.0000		6			
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Location	Loc Qty	Loc Code
WA003	6	
107521	6	

B107828 -> 5

(S) 14-04-16 PD

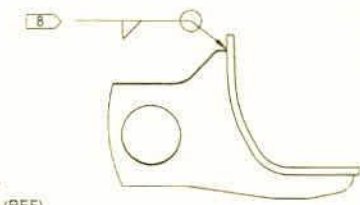
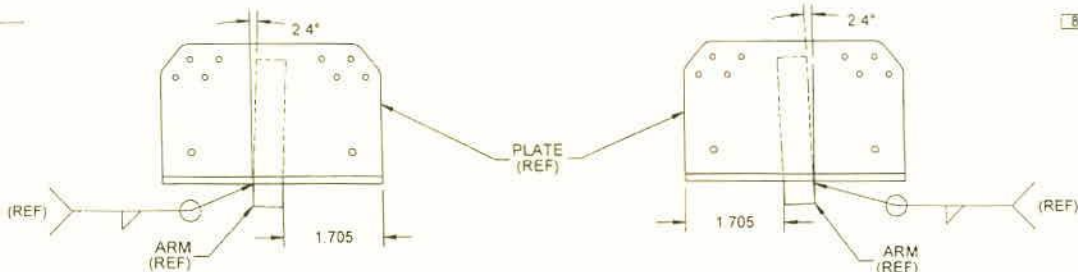
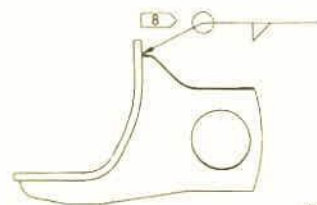
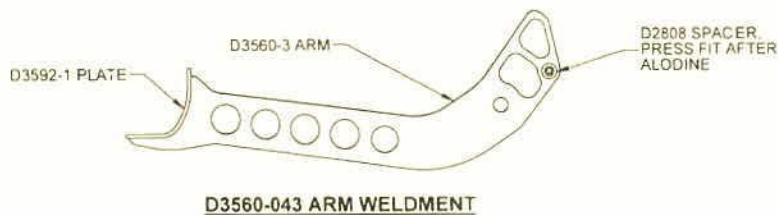
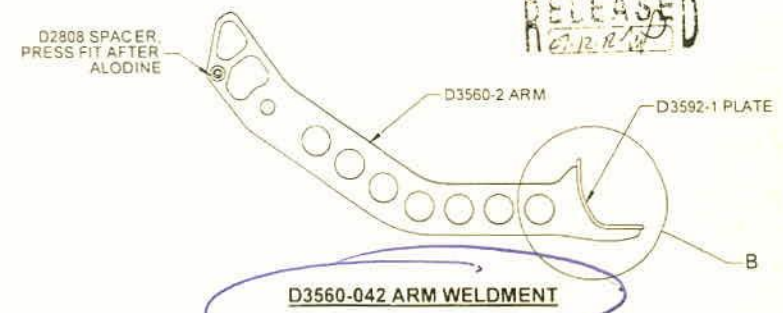
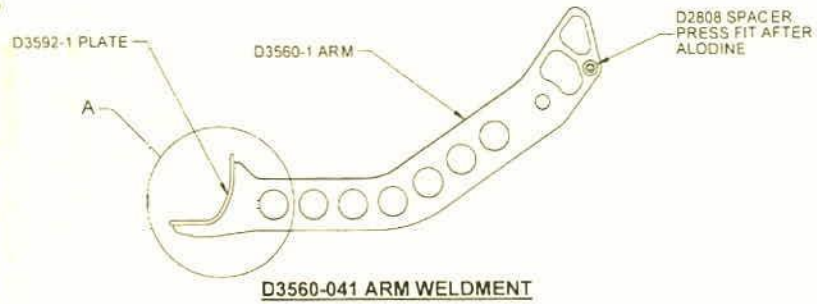
D3592-1 Plate		Manufactured	No				Each	43.0000		6			
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Location	Loc Qty	Loc Code
WA002	2	
47015	2	
WA003	41	
103585	3	
106184	23	
82022	8	
97778	7	

B10722 -> 5

(S) 14-04-16 PD

RELEASED  
27.12.12



**PARTS LIST**

QTY -041	QTY -042	QTY -043	QTY -044	P/N	DESCRIPTION
X				D3560-041	ARM WELDMENT
	X			D3560-042	ARM WELDMENT
		X		D3560-043	ARM WELDMENT
			X	D3560-044	ARM WELDMENT
1	1	1	1	D2808	SPACER
1				D3560-1	ARM
	1			D3560-2	ARM
		1		D3560-3	ARM
			1	D3560-4	ARM
1	1	1	1	D3592-1	PLATE

- NOTES**
- 1) MATERIAL: N/A
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4 1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX.
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 1.23 lbs (TYP)
  - 8) WELDING: PER DART QSI 004

D	ADD D2808 PRESS FIT NOTE, REDRAWN IN SOLIDWORKS	DC	07.11.16
C	REMOVE POWDER COAT	CP	07.06.19
B	REDESIGN AS WELDMENT, ADD POCKETS	CP	07.01.15
A	NEW ISSUE	CP	06.09.25
REV	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG APPR			
APPROVED			
DE APPR			
DATE	07.11.16		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO: **D3560**

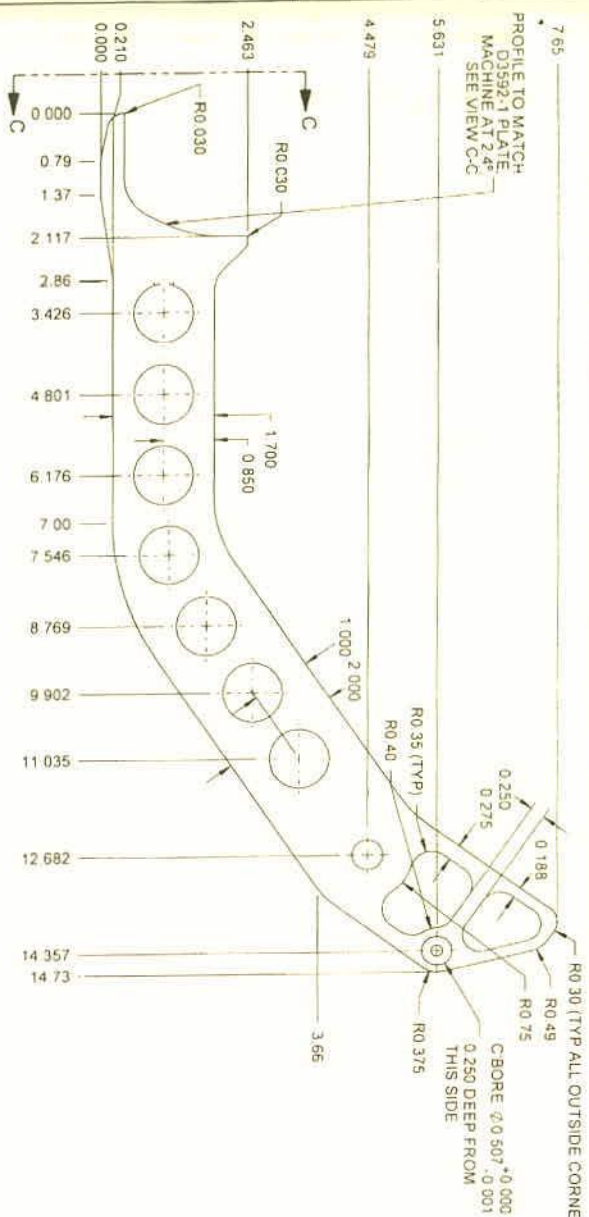
TITLE: **ARM WELDMENT**

REV D  
SHEET 1 OF 5  
SCALE: 1:4

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108848 MJS  
13-10-30

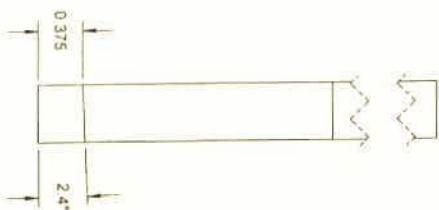
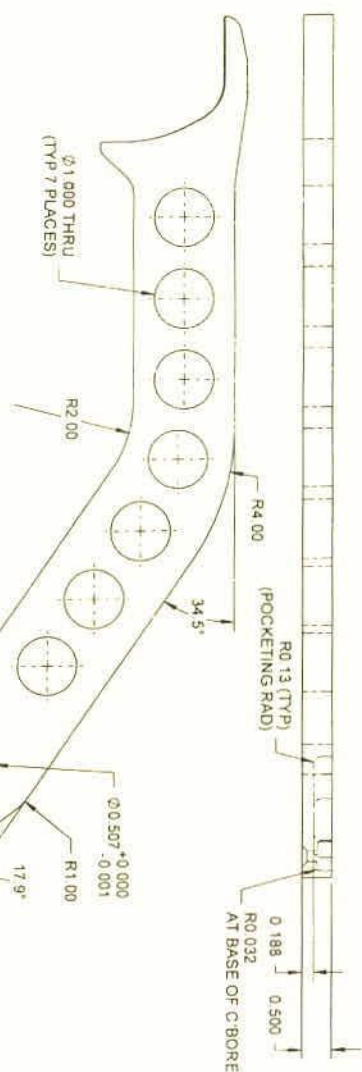




D3560-1 ARM WELDMENT

## NOTES

- 1) MATERIAL: 6061-T6 (OR 6061-T6511/6061-T6511/6021 BAR, 0.500 THICK)  
PER AMS-QQ-A-225/8 (OR AMS-QQ-A-417/417A/417B/417C/417D/417E/417F/417G/417H/417I/417J/417K/417L/417M/417N/417O/417P/417Q/417R/417S/417T/417U/417V/417W/417X/417Y/417Z/417AA/417AB/417AC/417AD/417AE/417AF/417AG/417AH/417AI/417AJ/417AK/417AL/417AM/417AN/417AO/417AP/417AQ/417AR/417AS/417AT/417AU/417AV/417AW/417AX/417AY/417AZ/417BA/417BB/417BC/417BD/417BE/417BF/417BG/417BH/417BI/417BJ/417BK/417BL/417BM/417BN/417BO/417BP/417BQ/417BR/417BS/417BT/417BU/417BV/417BW/417BX/417BY/417BZ/417CA/417CB/417CC/417CD/417CE/417CF/417CG/417CH/417CI/417CJ/417CK/417CL/417CM/417CN/417CO/417CP/417CQ/417CR/417CS/417CT/417CU/417CV/417CW/417CX/417CY/417CZ/417DA/417DB/417DC/417DD/417DE/417DF/417DG/417DH/417DI/417DJ/417DK/417DL/417DM/417DN/417DO/417DP/417DQ/417DR/417DS/417DT/417DU/417DV/417DW/417DX/417DY/417DZ/417EA/417EB/417EC/417ED/417EE/417EF/417EG/417EH/417EI/417EJ/417EK/417EL/417EM/417EN/417EO/417EP/417EQ/417ER/417ES/417ET/417EU/417EV/417EW/417EX/417EY/417EZ/417FA/417FB/417FC/417FD/417FE/417FF/417FG/417FH/417FI/417FJ/417FK/417FL/417FM/417FN/417FO/417FP/417FQ/417FR/417FS/417FT/417FU/417FV/417FW/417FX/417FY/417FZ/417GA/417GB/417GC/417GD/417GE/417GF/417GG/417GH/417GI/417GJ/417GK/417GL/417GM/417GN/417GO/417GP/417GQ/417GR/417GS/417GT/417GU/417GV/417GW/417GX/417GY/417GZ/417HA/417HB/417HC/417HD/417HE/417HF/417HG/417HH/417HI/417HJ/417HK/417HL/417HM/417HN/417HO/417HP/417HQ/417HR/417HS/417HT/417HU/417HV/417HW/417HX/417HY/417HZ/417IA/417IB/417IC/417ID/417IE/417IF/417IG/417IH/417II/417IJ/417IK/417IL/417IM/417IN/417IO/417IP/417IQ/417IR/417IS/417IT/417IU/417IV/417IW/417IX/417IY/417IZ/417JA/417JB/417JC/417JD/417JE/417JF/417JG/417JH/417JI/417JJ/417JK/417JL/417JM/417JN/417JO/417JP/417JQ/417JR/417JS/417JT/417JU/417JV/417JW/417JX/417JY/417JZ/417KA/417KB/417KC/417KD/417KE/417KF/417KG/417KH/417KI/417KJ/417KK/417KL/417KM/417KN/417KO/417KP/417KQ/417KR/417KS/417KT/417KU/417KV/417KW/417KX/417KY/417KZ/417LA/417LB/417LC/417LD/417LE/417LF/417LG/417LH/417LI/417LJ/417LK/417LL/417LM/417LN/417LO/417LP/417LQ/417LR/417LS/417LT/417LU/417LV/417LW/417LX/417LY/417LZ/417MA/417MB/417MC/417MD/417ME/417MF/417MG/417MH/417MI/417MJ/417MK/417ML/417MM/417MN/417MO/417MP/417MQ/417MR/417MS/417MT/417MU/417MV/417MW/417MX/417MY/417MZ/417NA/417NB/417NC/417ND/417NE/417NF/417NG/417NH/417NI/417NJ/417NK/417NL/417NM/417NN/417NO/417NP/417NQ/417NR/417NS/417NT/417NU/417NV/417NW/417NX/417NY/417NZ/417OA/417OB/417OC/417OD/417OE/417OF/417OG/417OH/417OI/417OJ/417OK/417OL/417OM/417ON/417OO/417OP/417OQ/417OR/417OS/417OT/417OU/417OV/417OW/417OX/417OY/417OZ/417PA/417PB/417PC/417PD/417PE/417PF/417PG/417PH/417PI/417PJ/417PK/417PL/417PM/417PN/417PO/417PP/417PQ/417PR/417PS/417PT/417PU/417PV/417PW/417PX/417PY/417PZ/417QA/417QB/417QC/417QD/417QE/417QF/417QG/417QH/417QI/417QJ/417QK/417QL/417QM/417QN/417QO/417QP/417QQ/417QR/417QS/417QT/417QU/417QV/417QW/417QX/417QY/417QZ/417RA/417RB/417RC/417RD/417RE/417RF/417RG/417RH/417RI/417RJ/417RK/417RL/417RM/417RN/417RO/417RP/417RQ/417RR/417RS/417RT/417RU/417RV/417RW/417RX/417RY/417RZ/417SA/417SB/417SC/417SD/417SE/417SF/417SG/417SH/417SI/417SJ/417SK/417SL/417SM/417SN/417SO/417SP/417SQ/417SR/417SS/417ST/417SU/417SV/417SW/417SX/417SY/417SZ/417TA/417TB/417TC/417TD/417TE/417TF/417TG/417TH/417TI/417TJ/417TK/417TL/417TM/417TN/417TO/417TP/417TQ/417TR/417TS/417TT/417TU/417TV/417TW/417TX/417TY/417TZ/417UA/417UB/417UC/417UD/417UE/417UF/417UG/417UH/417UI/417UJ/417UK/417UL/417UM/417UN/417UO/417UP/417UQ/417UR/417US/417UT/417UU/417UV/417UW/417UX/417UY/417UZ/417VA/417VB/417VC/417VD/417VE/417VF/417VG/417VH/417VI/417VJ/417VK/417VL/417VM/417VN/417VO/417VP/417VQ/417VR/417VS/417VT/417VU/417VV/417VW/417VX/417VY/417VZ/417WA/417WB/417WC/417WD/417WE/417WF/417WG/417WH/417WI/417WJ/417WK/417WL/417WM/417WN/417WO/417WP/417WQ/417WR/417WS/417WT/417WU/417WV/417WW/417WX/417WY/417WZ/417XA/417XB/417XC/417XD/417XE/417XF/417XG/417XH/417XI/417XJ/417XK/417XL/417XM/417XN/417XO/417XP/417XQ/417XR/417XS/417XT/417XU/417XV/417XW/417XX/417XY/417XZ/417YA/417YB/417YC/417YD/417YE/417YF/417YG/417YH/417YI/417YJ/417YK/417YL/417YM/417YN/417YO/417YP/417YQ/417YR/417YS/417YT/417YU/417YV/417YW/417YX/417YY/417YZ/417ZA/417ZB/417ZC/417ZD/417ZE/417ZF/417ZG/417ZH/417ZI/417ZJ/417ZK/417ZL/417ZM/417ZN/417ZO/417ZP/417ZQ/417ZR/417ZS/417ZT/417ZU/417ZV/417ZW/417ZX/417ZY/417ZZ/417AAA/417AAB/417AAC/417AAD/417AAE/417AAF/417AAG/417AAH/417AAI/417AAJ/417AAK/417AAL/417AAM/417AAN/417AAO/417AAP/417AAQ/417AAR/417AAS/417AAT/417AAU/417AAV/417AAW/417AAX/417AAZ/417AAA/417AAB/417AAC/417AAD/417AAE/417AAF/417AAG/417AAH/417AAI/417AAJ/417AAK/417AAL/417AAM/417AAN/417AAO/417AAP/417AAQ/417AAR/417AAS/417AAT/417AAU/417AAV/417AAW/417AAX/417AAZ/417AAA/417AAB/417AAC/417AAD/417AAE/417AAF/417AAG/417AAH/417AAI/417AAJ/417AAK/417AAL/417AAM/417AAN/417AAO/417AAP/417AAQ/417AAR/417A



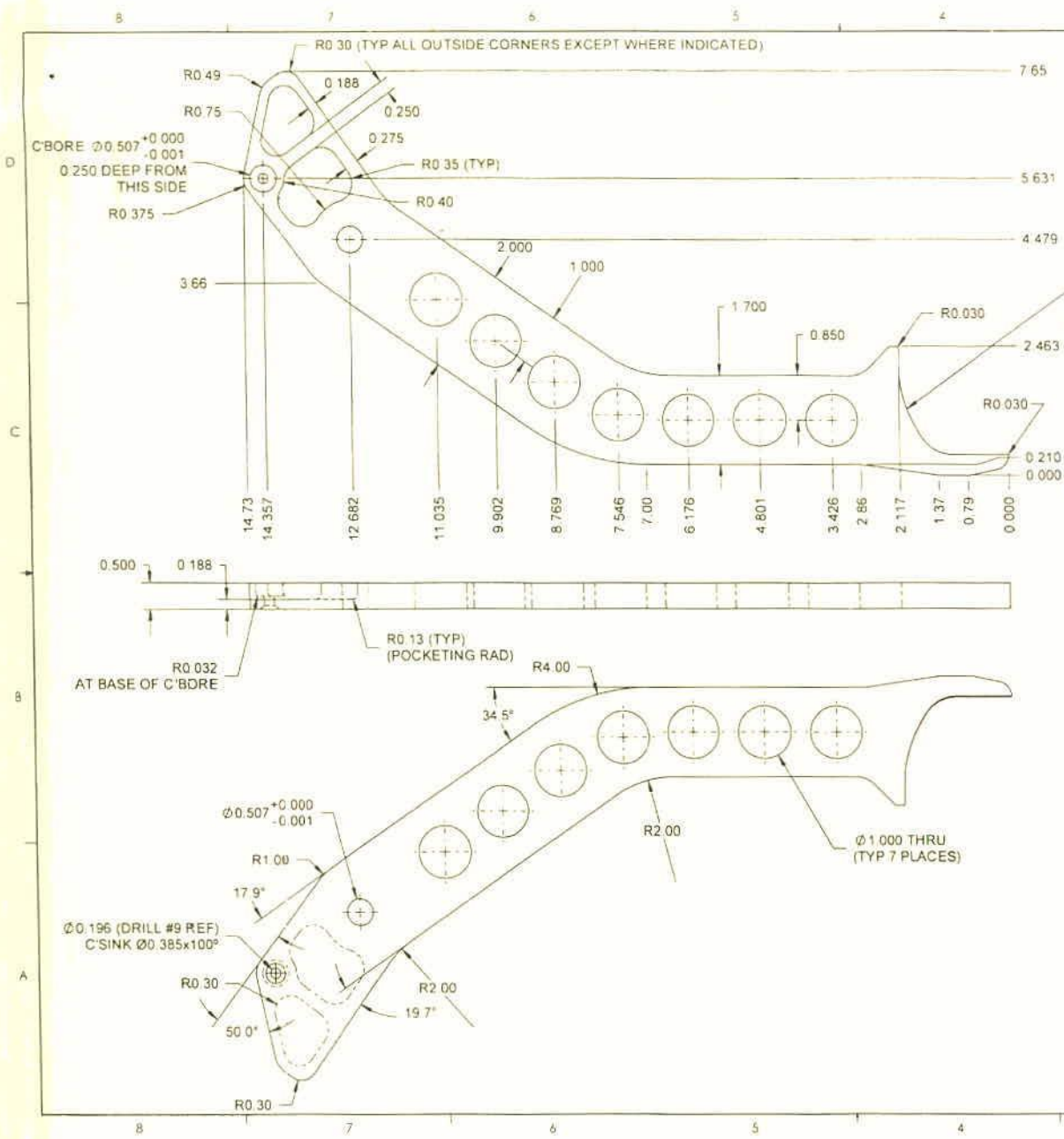
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DRAWN	JK	
CHECKED	JK	
MFG APPR	JK	
APPROVED	JK	
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108848



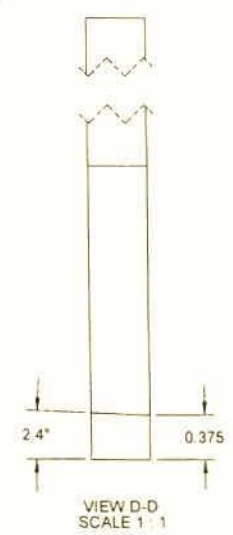
108848



PROFILE TO MATCH  
D3592-1 PLATE  
MACHINE AT 2.4°  
SEE VIEW D-D

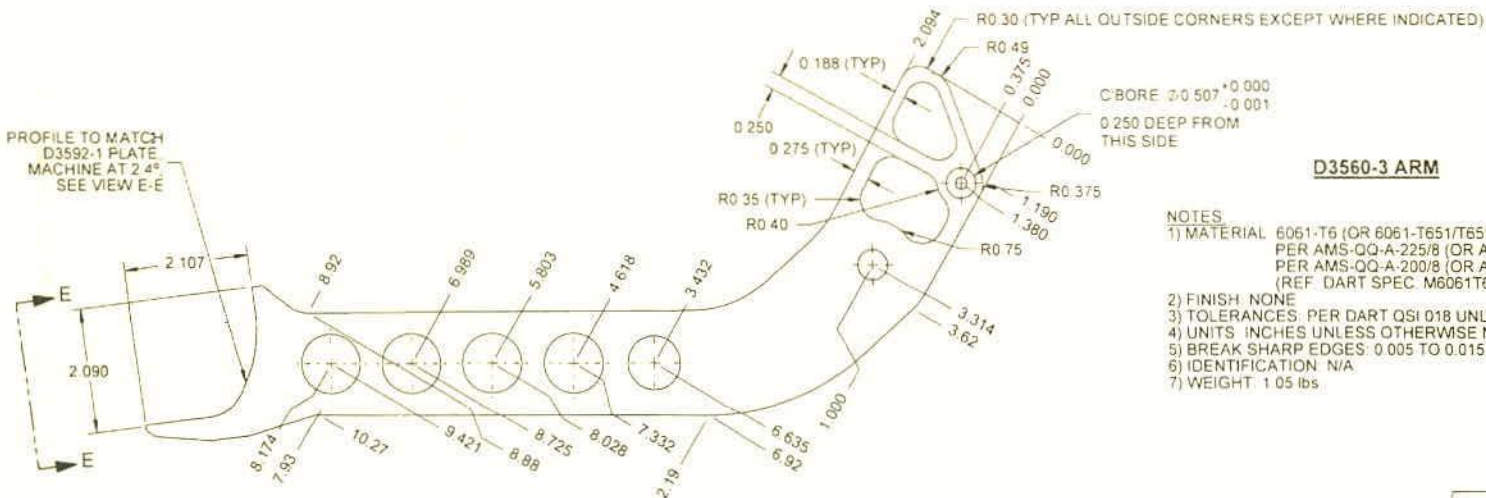
### D3560-2 ARM

- NOTES:
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF: DART SPEC. M6061T6B0 500)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 1.05 lbs



DESIGN	g	DART AEROSPACE LTD	
DRAWN	jc	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO	REV D
MFG APPR		D3560	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR		ARM WELDMENT	1:2
DATE	07.11.16	COPYRIGHT © 2006 BY DART AEROSPACE LTD	
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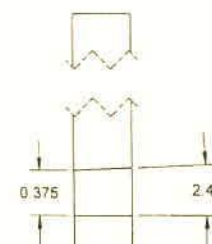
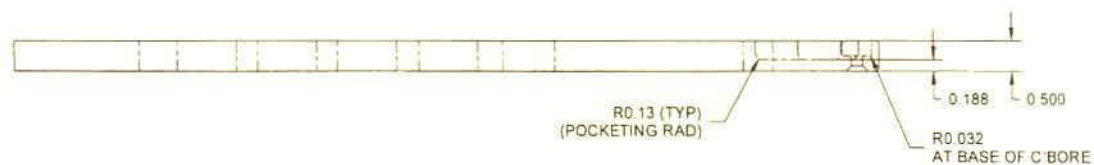
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D3592-1 PLATE  
MACHINE AT 2.4°  
SEE VIEW E-E



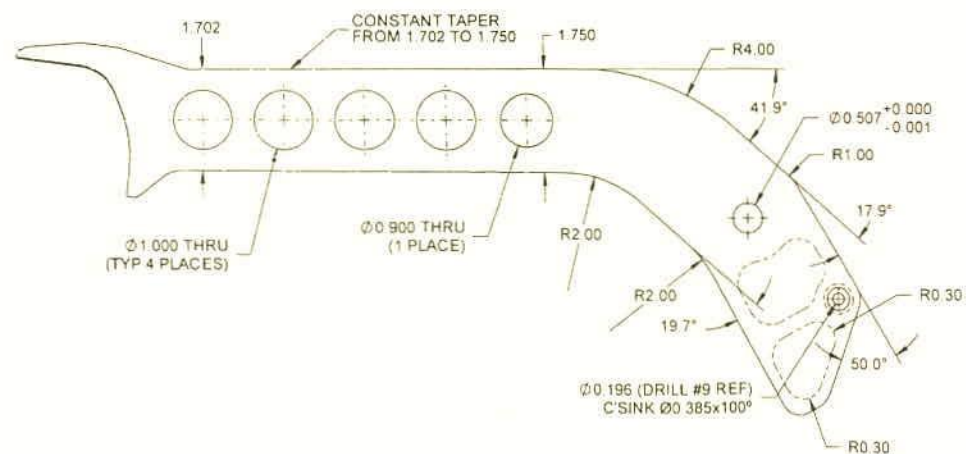
D3560-3 ARM

## NOTES

- NOTES
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, Ø 500 THICK  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF DART SPEC M6061T6B0.500)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 1.05 lbs



VIEW E-E  
SCALE 1 : 1



DESIGN	q	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA  DRAWING NO. <b>D3560</b>  TITLE <b>ARM WELDMENT</b>  COPYRIGHT © 2006 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DOWN LOADED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>	REV D
DRAWN	4C		SHEET 4 OF 5
CHECKED	11		SCALE
MFG APPR			12
APPROVED	110		
DE APPR	*		
DATE	07.11.16		





